

Work Order ID 63322

Page 1

Wednesday, October 27, 2010 3:01:37 PM

Item ID: D4170-1

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 10/27/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/10/27 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4170	A
-------	---

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo

0.00

30

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

30

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63322

Page 2

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

30 / / BG 10/11/10

130

Identify as per dwg & Stock Location: LC

0.00

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

30 / / BG 10/11/10

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

4K 10/11/11 AF

MF
10-11-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Wednesday, October 27, 2010 3:01:40 PM

Work Order ID: 63322



Parent Item: D4170-1



Parent Item Name: Bushing

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	99.1160	0.2666	8.418947		10.11.9	

6061-T6 RD Tube .375 x.058W

Location Loc Qty Loc Code

MAT014 99.116

110968 1.416

113718 1.7

115901 96

 7.9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63322
Description: Spacer	Part Number:	D4170-1
Inspection Dwg: D4170 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	Audited by:	Preliminary Approval:
Date: 10-11-09	Date: 10/11/09	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.08	New Issue	KJ	 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

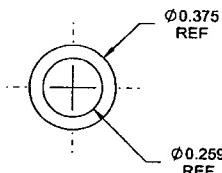
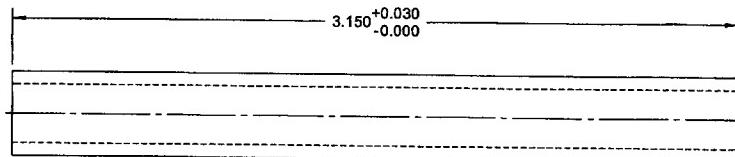
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 6332

2

BJ10-10-27



D4170-1 SPACER

RELEASED
2010-09-15
AM

NOTES:

- NOTES:**

 - 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-7006/0 OR AMS 4080 OR AMS 4082 OR
PER QQ-A-208/0 OR QQ-A-225/8
REF. DART SPEC. M6061T6T0.375W.058
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01lbs

A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED	(initials)	DRAWING NO.	REV. A	
MFG. APPR.	(initials)	D4170	SHEET 1 OF 1	
APPROVED	(initials)	TITLE	SCALE	
DE APPR.	(initials)	SPACER	NTS	
DATE	10.07.22		<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE USA, INC.</small>	

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